

Date: Friday, 11/17/2006 9:04:50 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212/205 HIGH FED X-TUBE ASSEMBLY
Job Number : 29500	
Estimate Number : 10254	
P.O. Number : N/A	Part Number : D212664101
This Issue : 11/17/2006 S.O. No. : N/A	Drawing Number : D212-664-141 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : B
Previous Run : 27987	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 12/15/2006 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:E 04.02.16 Reformat KJ/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101CHG002

KJ 06.11.20

2.0

D6005128

Crosstube material

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6005-128 Crosstube 25665

Check OD = 2.750"; ID = 2.000"

BG 06.11.19

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE

**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113

2-Turn first side as per Folio FA113

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141. BG 06.11.20

4.0

QC1

INSPECT ALL DIM TO DIM SHEET

**Comment:** INSPECT ALL DIM TO DIM SHEET

BG 06.11.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:04:50 AM
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Job Number: 29500

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA113

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141. BG 06.11.20 1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

BG 06.11.20 1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.11.20 1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Polish entire outside surface of crosstube

M-R/DP 06/12/06 ①

2-Remove sand and plugs

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

BG 06.11.20 1

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-R 06/12/06 ①

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Pm 06-12-80 ①

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

DP/EL 11/18/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

Date: Friday, 11/17/2006 9:04:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 29500

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC6

DIMENSIONAL CHECK



06-12-20 (1)



Comment: DIMENSIONAL CHECK

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

ET /R 06/12/29

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

ET /R 06/12/29

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

DP /R 07-1-2

14.0

HAND FINISHING 1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

ET /R 07-01-03

15.0

QC5

INSPECT WORK TO CURRENT STEP



07-01-10 (1)



Comment: INSPECT WORK TO CURRENT STEP

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: *2846*

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C 70710111 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

07/01/17

18.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

07/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 29500

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

ML 07 01 24

①

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ML 07 01 24

②

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

207-01-30 ①

21.0

D2856600

Abrasion Strip



Comment: Qty.: 0.7090 f(s)/Unit Total : 0.7090 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-851 Abrasion Strip 326670

RT 07 01 30

*

22.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1 Support 327475

RT 07-01-30

*

23.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-24 Clamp M102932

RT 07-01-30

*

24.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8581

2-Install supports and clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

} RT 07-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 29500

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



2070131 (1)



Comment: INSPECT WORK TO CURRENT STEP

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLACARD

Batch: *B26018 ✓*

28.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: *M101340 2x ✓ M101697 2x ✓*

29.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: *M101697 2x ✓ M102929 2x ✓*

30.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: *M102829 ✓*

31.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: *M100151 ✓*

Batch 31 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 29500

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 7/01/31(1)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

NEB

PC 7/01/31(1)

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
PC 7/01/31(1)

Job Completion



U 67.02.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29500
Description: Crosstube Assembly (205/212/412 High Fwd)	Part Number:	D212-664-141
Inspection Dwg: D212-664-141 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

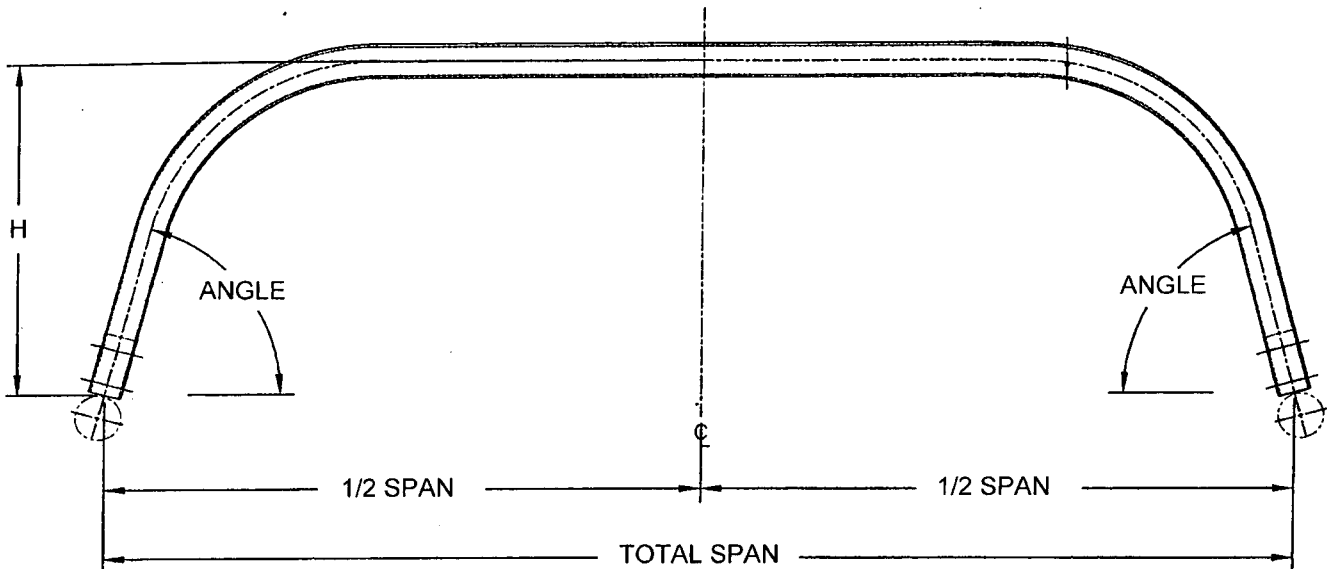
☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	200	✓			
	R0.063	+/-0.010	063	✓			
	2.740	+0.005/-0.000	2.744	✓			
	5.097	+/-0.030	5.097	✓			
	2.304	+0.005/-0.000	2.308	✓			
	2.340	+0.005/-0.000	2.341	✓			
	2.398	+0.005/-0.000	2.402	✓			
	2.448	+0.005/-0.000	2.452	✓			
	2.498	+0.005/-0.000	2.502	✓			
	2.549	+0.005/-0.000	2.553	✓			
	2.599	+0.005/-0.000	2.603	✓			
	2.671	+0.005/-0.000	2.675	✓			
	2.701	+0.005/-0.000	2.703	✓			
SIDE B	0.200	+/-0.010	200	✓			
	R0.063	+/-0.010	063	✓			
	2.740	+0.005/-0.000	2.742	✓			
	5.097	+/-0.030	5.097	✓			
	2.304	+0.005/-0.000	2.308	✓			
	2.340	+0.005/-0.000	2.344	✓			
	2.398	+0.005/-0.000	2.402	✓			
	2.448	+0.005/-0.000	2.452	✓			
	2.498	+0.005/-0.000	2.502	✓			
	2.549	+0.005/-0.000	2.553	✓			
	2.599	+0.005/-0.000	2.603	✓			
	2.671	+0.005/-0.000	2.675	✓			
	2.701	+0.005/-0.000	2.705	✓			
	126.51	+/-0.020	126.51	✓			

Measured by:	SG	Audited by:	SD	Prototype Approval:	N/A
Date:	06.11.20	Date:	06.11.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	

Crosstube Bend Dimension Sheet



PART NUMBER: _____

BATCH NUMBER: 29500

DRAWING: _____ REVISION: _____

H: _____

1/2 SPAN: _____

TOTAL SPAN: _____

ANGLE: _____

QC 15: _____

DATE: _____

QTY: _____



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D212-664-141	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05-06-09-11

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
2	D2856-600-851	ABRASION STRIP
4	MS21920-24	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 9) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN.-LB.

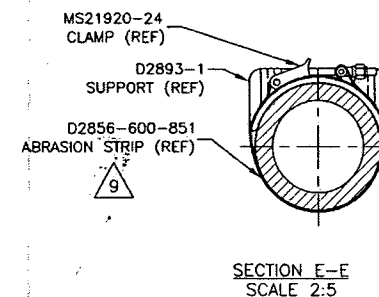
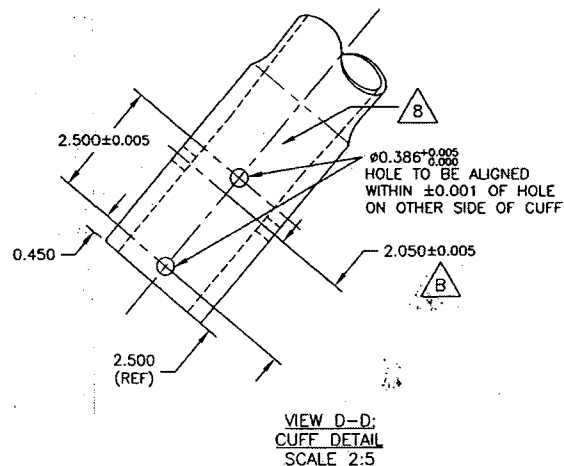
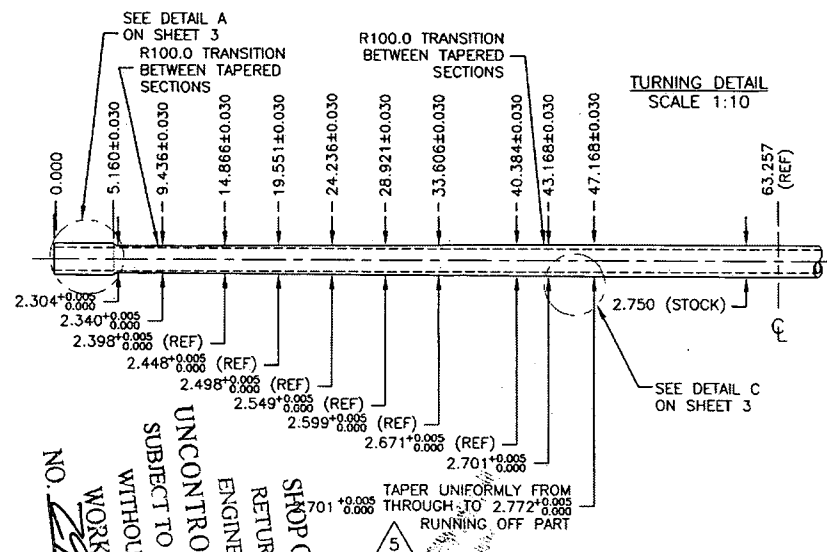
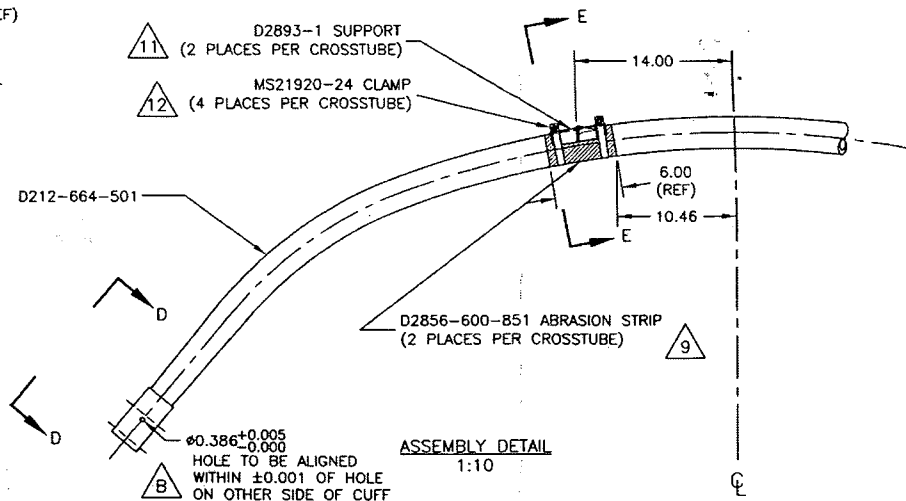
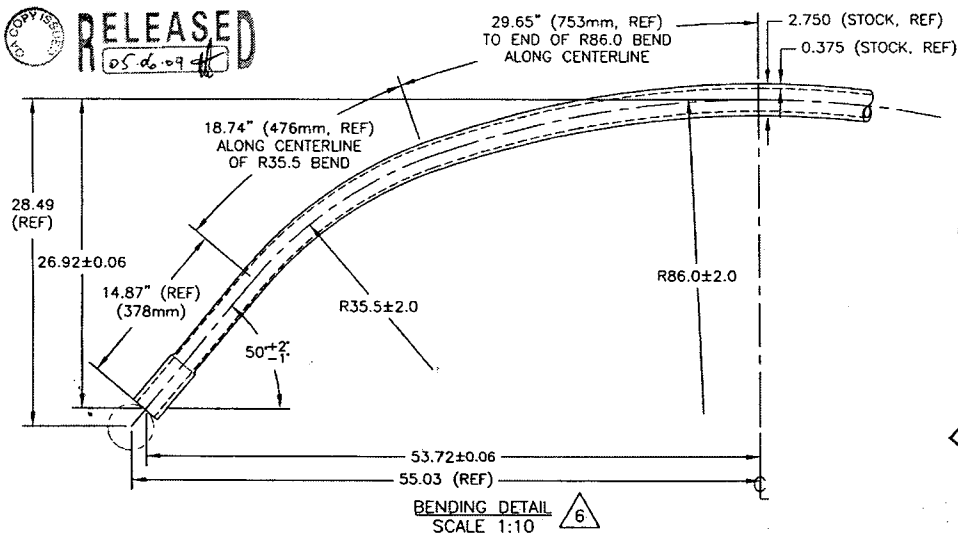
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WITHOUT NOTICE
WORK ORDER
NO. 29500

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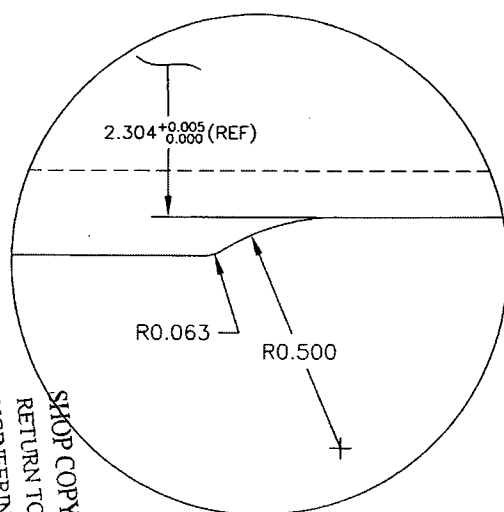
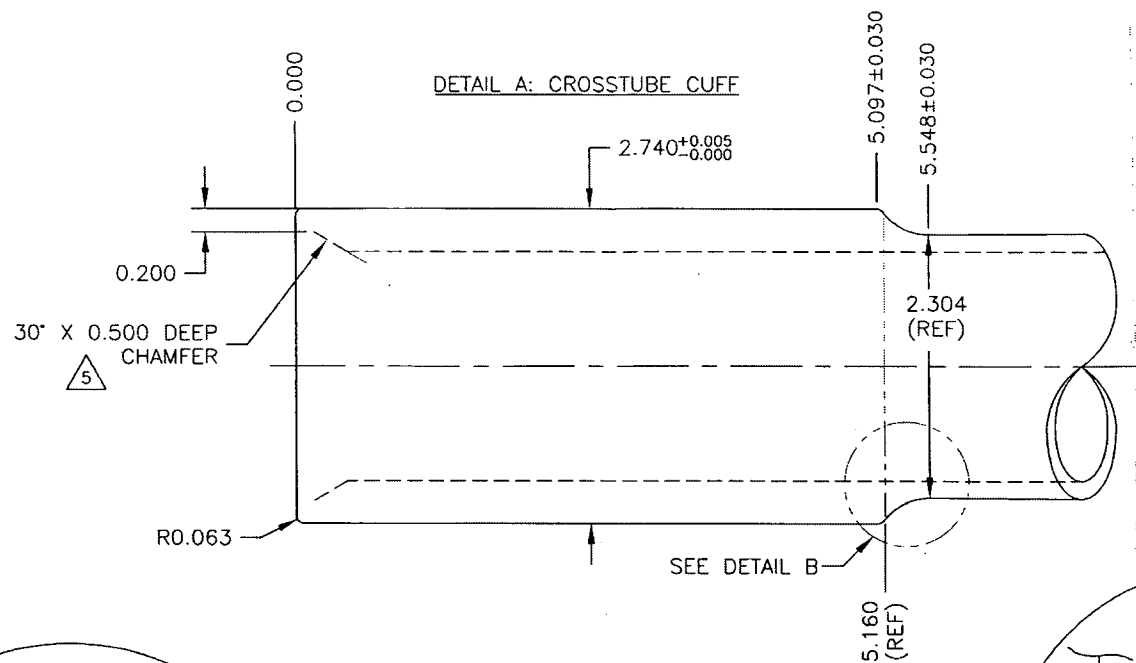


NO. 29500
WORK ORDER
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED PH	APPROVED PH	DRAWING NO. D212-664-141
DATE 05.02.04		TITLE XTUBE ASS'Y (205/212/412 HI FWD)		REV. B SHEET 2 OF 3 SCALE 1:10

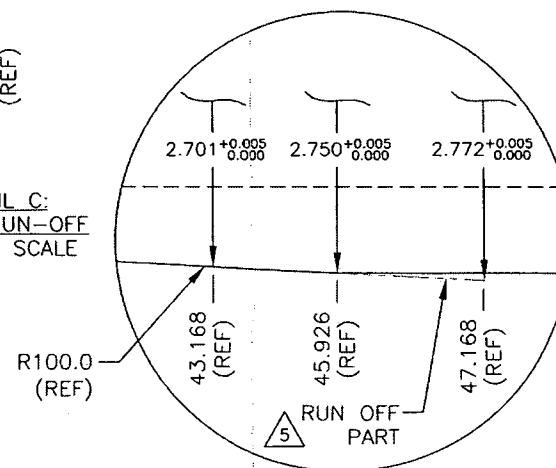


RELEASED



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DART AEROSPACE LTD.
MARKHAM, ONTARIO, CANADA

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DRAWING NO.

D212-664-141

REV. B

SHEET 3 OF 3

DATE

05.02.04

TITLE

XTUBE ASS'Y (205/212/412 HI FWD)

SCALE

1:1

NO. 29520

WORK ORDER

SUBJECT TO AMENDMENT

WITHOUT NOTICE

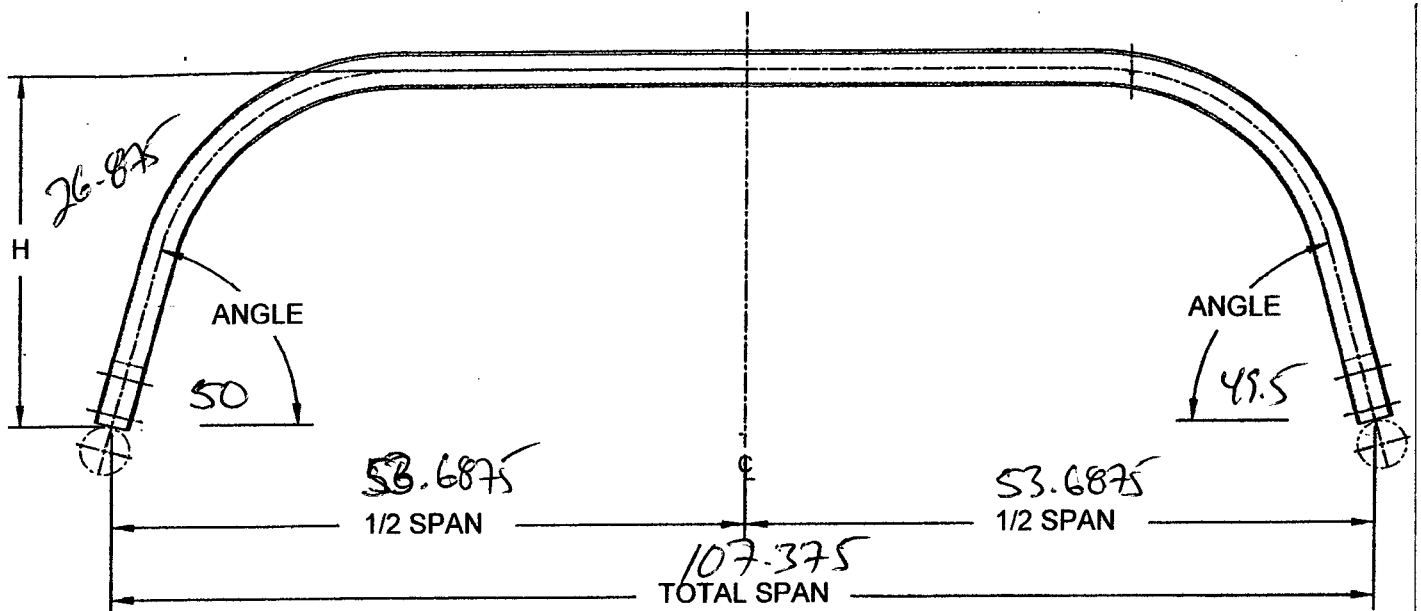
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Crosstube Bend Dimension Sheet



PART NUMBER: D212-664-101

BATCH NUMBER: 29500

DRAWING: D212-664-141

REVISION: B

H: 26.92

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50

QC 15: [Signature]

DATE: 06-12-20

QTY: 1

1000
1000
1000
1000

6



Hea hAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 35529

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (11) cross tube (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (7) P/N D212-664-101 S/N's B29500, B29505, B29504, B27625, B29501, B27984 & B27986

Qty (4) P/N D212-664-201 S/N's B29509, B27991, B29507 & B28761.



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (11) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)

Ardrox 970P25E Batch #04B503.

Four (4) cross tubes (P/N D212-664-201) FAILED inspection. Areas marked on cross tubes (S/N's B29509, B27991, B29507 & B28761). To be reinspected following repair.

Seven (7) cross tubes (P/N D212-664-101) PASSED inspection (S/N's B29500, B29505, B29504, B27625, B29501, B27984 & B27986).

22/01/17

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: _____

DATE January 12, 2007

INSPECTION
STAMP(S) Not Required

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

2846

ADDRESS:

CONTACT NAME:

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO.

TOTAL \$

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